

Date: Tuesday, 07/04/2009 10:17:09 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP STRUT		
Job Number	: 46946			Part Number	: D2017129		
Estimate Number	: 11941			Drawing Number	: D2017 REV E1 F		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/04/2009	S.O. No.	:	Drawing Revision	: E1 F		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 22/04/2009		
Previous Run	: 43578			Qty:	4 Um: Each		
Written,By	:						
Checked & Approved By	: JUL 09.04.01						
Comment	: Est F 02.06.19 Update processes (Ref. ECN 435) KJ						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
<p>Comment: Qty.: 2.7738 f(s)/Unit Total : 11.0951 f(s) Punch tube type 304-2B, $\frac{3}{4}$" Ø. X .049" wall to length per Dwg. D2017 & spec control D2638 Batch No. <u>M111331</u> SB 09/04/27 (4)</p> <p>Deburr </p>		
2.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP S 09/04/28 (4)</p>		
3.0	POWDER COATING	POWDER COATING <u>m109996</u> (xy)
<p>Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3</p> <p>START TIME: <u>7:15</u> OVEN TEMPERATURE: <u>400</u> FINISH TIME: <u>7:45</u> cmo fl <u>09/04/28</u> (4)</p>		
4.0	QC3	INSPECT POWDER COAT/ CHEMICAL CONVERSION <u>fl 09/04/29</u> (4)
<p>Comment: INSPECT POWDER COAT</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP STRUT

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 258

JS 09/04/30 (x4)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

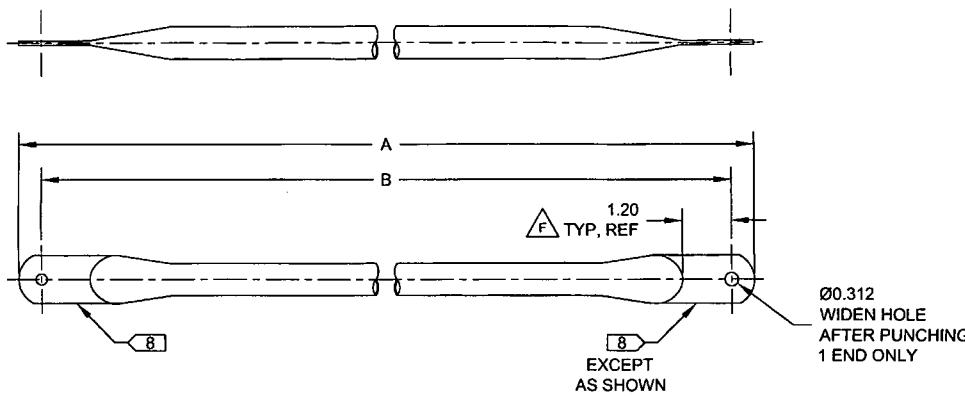
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-101	17.73	16.93
D2017-103	18.74	17.94
D2017-113	20.50	19.70

RELEASED
 09/04/16

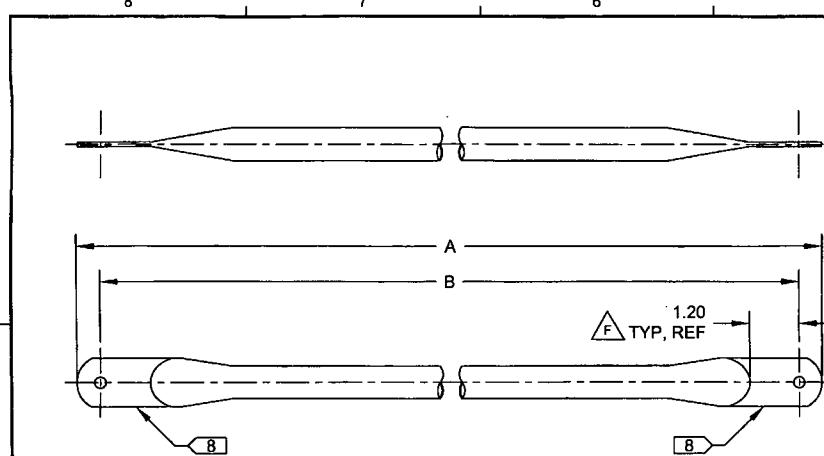
F	DRAWING TRANSFERRED TO "B" FORMAT AND TO CURRENT STANDARDS. REDRAWN FOR CLARITY 1.20 REF DIM ADDED. SEE PAR 09-002 FOR DETAILS.	AJS	09.03.06
E	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897) ADD FINISH (INCORPORATE E1)	CP	02.03.22
D	ADDED PARTS	BW	96.03.28
C	ADDED PARTS	BW	95.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2017	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP STRUTS	NTS
DATE	09.03.06	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS UNPUBLISHED. IT IS NOT TO BE USED FOR ANY FORM OF FURTHER PUBLICATION, OR REPRODUCED OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.750 x 0.049 WALL
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2017-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) PUNCH ENDS PER SPEC CONTROL DRAWING D2638.

NO. 1404
 WORK ORDER
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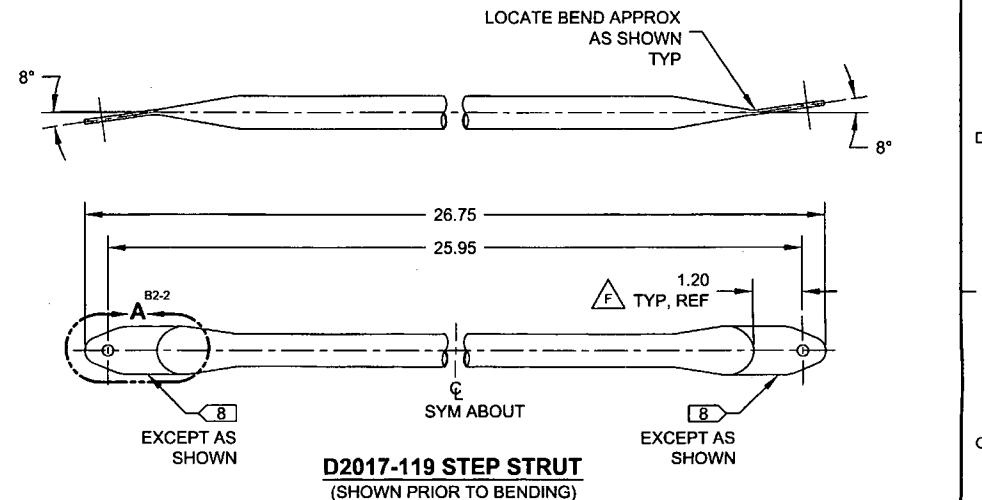
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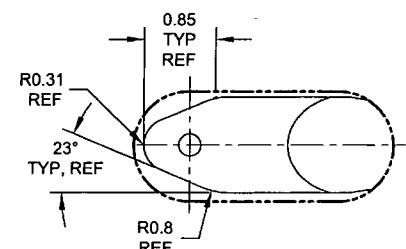
D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-105	14.95	14.15
D2017-107	15.61	14.81
D2017-109	13.93	13.13
D2017-111	15.30	14.50
D2017-115	12.42	11.62
D2017-117	13.86	13.06
D2017-121	12.30	11.50
D2017-123	12.92	12.12
D2017-125	19.55	18.75
D2017-127	20.30	19.50
D2017-129	31.43	30.63
D2017-131	19.68	18.88
D2017-201	21.31	20.51
D2017-203	16.39	15.59
D2017-205	16.53	15.73
D2017-207	13.85	13.05
D2017-209	15.64	15.33
D2017-211	15.67	14.87
D2017-213	15.82	15.02
D2017-215	16.47	15.67
D2017-217	16.70	15.90
D2017-219	13.65	12.85
D2017-221	13.58	12.78
D2017-223	12.95	12.15
D2017-225	13.99	13.19
D2017-227	30.67	29.87
D2017-133	30.66	29.86

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D2017-119 STEP STRUT
(SHOWN PRIOR TO BENDING)



DETAIL A D4-2
TRIM AFTER PUNCHING PER DT8360
SCALE 2X

RELEASED
09/04/16 M/S

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. F	
APPROVED		D2017	
DE APPR.		SHEET 2 OF 2	
DATE	09.03.06	TITLE	
		STEP STRUTS	
NTS			

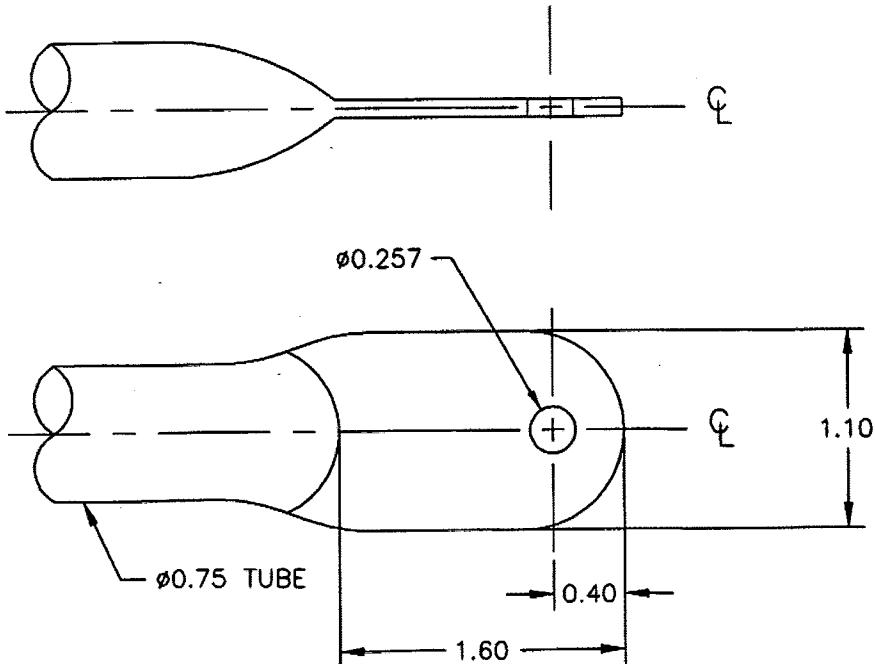
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DART

DESIGN CHECKED DATE	DRAWN BY APPROVED	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D2638
		REV. A SHEET 1 OF 1
98.04.28		TITLE PUNCH DT8117 SPEC CONTROL SCALE 1:1
A	98.04.28	NEW ISSUE

RELEASED
45/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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